

PRODUCT PROFILE

<b>GENERIC DESCRIPTION</b>	Aliphatic Polyester Polyurethane
<b>COMMON USAGE</b>	Extremely hard, chemical-resistant urethane coating for applications in commercial, industrial, and marine environments with excellent resistance to abrasion, washdown conditions, corrosive fumes and chemical contact. Gloss retention among the best of air dried finishes.
<b>COLORS</b>	Available in the 16 standard StrataShield colors. Special colors available, please contact your Tnemec representative. <b>Note:</b> Certain colors may require multiple coats depending on the method of application and finish coat color. When feasible, the preceding coat should be in the same color family (blue, gray, etc.), but noticeably different.
<b>FINISH</b>	Semi-Gloss

COATING SYSTEM

<b>PRIMERS</b>	<b>Steel:</b> Series 20, 27, 66, L69, L69F, N69, N69F, V69, V69F, 90-97, 90-1K97, 104, L140, L140F, N140, N140F, V140, V140F, 161, 205. <b>Concrete:</b> Series 66, L69, L69F, N69, N69F, 104, 161, 201, 205, 208, 233, 237, 237SC, 238, 293SC, 280, 281, 287.
<b>INTERMEDIATE</b>	Series 20, 27, 66, L69, L69F, N69, N69F, 104, L140, L140F, N140, N140F, 161, 205, 210, 237, 238, 270, 273, 280, 281, 282, 287. <b>Note:</b> Before topcoating with Series 290, any Tnemec epoxy exterior exposed for more than three weeks must be scarified or reprimed with itself. Mechanically abrading or power-sanding is the preferred method of scarification. The maximum recoat time for Series 210, 237, 238, 280, 281 and 282 is 24 hours. Refer to those product data sheets. Inorganic zinc-rich primers require an epoxy intermediate coat. <b>Note:</b> Scarification using a power sander and 100 grit sandpaper, No. 60 mesh sanding screen or a coarse stripping pad is required if topcoating Series 290 with itself. <b>Note:</b> When applying Series 290 over a broadcast or mortar system, an epoxy grout coat is required.

SURFACE PREPARATION

<b>ALL SURFACES</b>	Prepare surfaces by method suitable for exposure and service. Refer to the appropriate primer data sheet for specific recommendations. Must be clean, dry and free of oil, grease and other contaminants.
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TECHNICAL DATA

VOLUME SOLIDS	67 ± 2.0% (mixed) †															
RECOMMENDED DFT	2.0 to 3.0 mils (50 to 75 microns) per coat. <b>Note:</b> Number of coats will vary depending on substrate (surface) and other variables. Contact your Tnemec representative.															
CURING TIME	<table><tr><th>Temperature</th><th>Min. Recoat</th><th>To Service</th><th>Chemical Resistance</th></tr><tr><td>75°F (24°C)</td><td>12 hours</td><td>24 hours</td><td>7 days</td></tr></table>	Temperature	Min. Recoat	To Service	Chemical Resistance	75°F (24°C)	12 hours	24 hours	7 days							
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75°F (24°C)	12 hours	24 hours	7 days													
	Curing time varies with surface temperature, air movement, humidity and film thickness.															
VOLATILE ORGANIC COMPOUNDS	<b>Unthinned:</b> 2.41 lbs/gallon (288 grams/litre) <b>Thinned 10% (Max) (No. 39 Thinner):</b> 2.76 lbs/gallon (330 grams/litre) <b>Thinned 10% (Max) (No. 42 Thinner):</b> 2.80 lbs/gallon (335 grams/litre) †															
HAPS	<b>Unthinned:</b> 0.16 lbs/gal solids <b>Thinned 10% (Max) (No. 39 Thinner):</b> 0.16 lbs/gal solids <b>Thinned 10% (Max) (No. 42 Thinner):</b> 0.16 lbs/gal solids															
THEORETICAL COVERAGE	1,075 mil sq ft/gal (26.4 m²/L at 25 microns). See APPLICATION for coverage rates. †															
NUMBER OF COMPONENTS	Two: Part A and Part B (2.5 Parts A to 1 Part B by volume)															
PACKAGING	<table><tr><th></th><th>PART A (Partially filled)</th><th>PART B (Partially filled)</th><th>When Mixed Yield</th></tr><tr><td>Large Kit</td><td>3 gallon pail</td><td>1 gallon can</td><td>3 gallons (11.4 L)</td></tr><tr><td>Small Kit</td><td>1 gallon can</td><td>1/2 gallon can</td><td>1 gallon (3.79 L)</td></tr></table>		PART A (Partially filled)	PART B (Partially filled)	When Mixed Yield	Large Kit	3 gallon pail	1 gallon can	3 gallons (11.4 L)	Small Kit	1 gallon can	1/2 gallon can	1 gallon (3.79 L)			
	PART A (Partially filled)	PART B (Partially filled)	When Mixed Yield													
Large Kit	3 gallon pail	1 gallon can	3 gallons (11.4 L)													
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NET WEIGHT PER GALLON	11.01 ± 0.25 lbs (5.0 ± 0.11 kg) (mixed) †															
STORAGE TEMPERATURE	Minimum 20°F (-7°C)    Maximum 110°F (43°C)															
TEMPERATURE RESISTANCE	(Dry) Continuous 250°F (121°C)    Intermittent 275°F (135°C)															
SHELF LIFE	Part A: 24 months; Part B: 12 months at recommended storage temperature.															
FLASH POINT - SETA	Part A: 104°F (40°C)    Part B: >200°F (93°C)															
HEALTH & SAFETY	Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product. <b>Keep out of the reach of children.</b>															

## CRU | SERIES 290

## APPLICATION

## COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Suggested	2.5 (65)	3.5 (90)	430 (39.9)
Minimum	2.0 (50)	3.0 (75)	537 (49.9)
Maximum	3.0 (75)	4.5 (115)	358 (33.3)

Allow for overspray and surface irregularities. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

## MIXING

Stir contents of each container, until uniform in consistency. Slowly mix 2.5 parts A component to 1 part B while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. Part B is moisture-sensitive and will react with atmospheric moisture. Unused material must be kept tightly closed at all times.

## THINNING

For airless spray, must be thinned 10% or 12 ounces (355 mL) per gallon with No. 42 Thinner. For brush or roller application, must be thinned up to 10% or 12 ounces (355 mL) with No. 39 Thinner. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.**

## POT LIFE

1 1/2 hours at 60°F (16°C)    1 1/4 hours at 75°F (24°C)    1 hour at 100°F (38°C)

## APPLICATION EQUIPMENT

## Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.011"-0.015" (230-330 microns)	2700-3000 psi (207-241 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60-100 mesh (250-150 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

**Roller:** Use 1/4" or 3/8" (6.4 mm to 9.5 mm) synthetic woven nap roller cover. The 1/4" covers generally provide the best flow and leveling properties.

**Brush:** Use high quality natural or synthetic bristle brushes.

## SURFACE TEMPERATURE

Minimum 40°F (4°C)    Maximum 135°F (57°C)

The surface should be dry and at least 5°F (3°C) above the dew point. This product is moisture-sensitive until cured.

Application of the coating above the maximum recommended dry film thickness may cause bubbles to form in the cured film.

## CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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